

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 82739

Thursday, April 05, 2012 1:01:22 PM

82739

Page 3

Item ID: D3697-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Support Plate, RH

Start Date: 4/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00				46			
Quality Control						4			
170	Identify as per dwg & Stock Location: WA	0.00							
170									
Packaging	Memo	0.00				6x			
Packaging	*****STOCK IN LARGE FAB*****								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quaiity Control									

12-04-18

12/4/19

mf
12-04-18

Dart Aerospace Ltd

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Picklist Print

Thursday, April 05, 2012 1:01:27 PM

Page 1

Work Order ID: 82739

82739

Parent Item: D3697-4

D3697-4

Parent Item Name: Support Plate, RH

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No		100	sf	261.7940	0.4569	2.885684			

M6061T6S 050

6061-T6 .050 Sheet

Location	Loc Qty	Loc Code
021	160	
1211920	160	
MAT021	101.794	
113216	10	
114799	76.794	
114993	15	

121192

3ms mmm
12-4-11

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DART AEROSPACE LTD		Work Order:	82739
Description: Support Plate, RH		Part Number:	D3697-4
Inspection Dwg: D3697 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.101	✓		Vern	HB-02
0.38	+/-0.030	0.383	✓		Vern	HB-02
0.75	+/-0.030	0.748	✓		Vern	HB-02
0.75	+/-0.030	0.751	✓		Vern	HB-02
0.28	+/-0.030	0.281	✓		Vern	HB-02
2.25	+/-0.030	2.249	✓		Vern	HB-02
3.50	+/-0.030	3.487	✓		Vern	HB-02
1.86	+/-0.030	1.863	✓		Vern	HB-02
3.44	+/-0.030	3.439	✓		Vern	HB-02
1.80	+/-0.030	1.799	✓		Vern	HB-02
0.050	+/-0.010	0.049	✓		Vern	HB-02

Measured by:	JM. A/H	Audited by:	S	Prototype Approval:	N/A
Date:	12-4-11	Date:	12/4/12	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	08.09.04	New Issue	KJ/DD		

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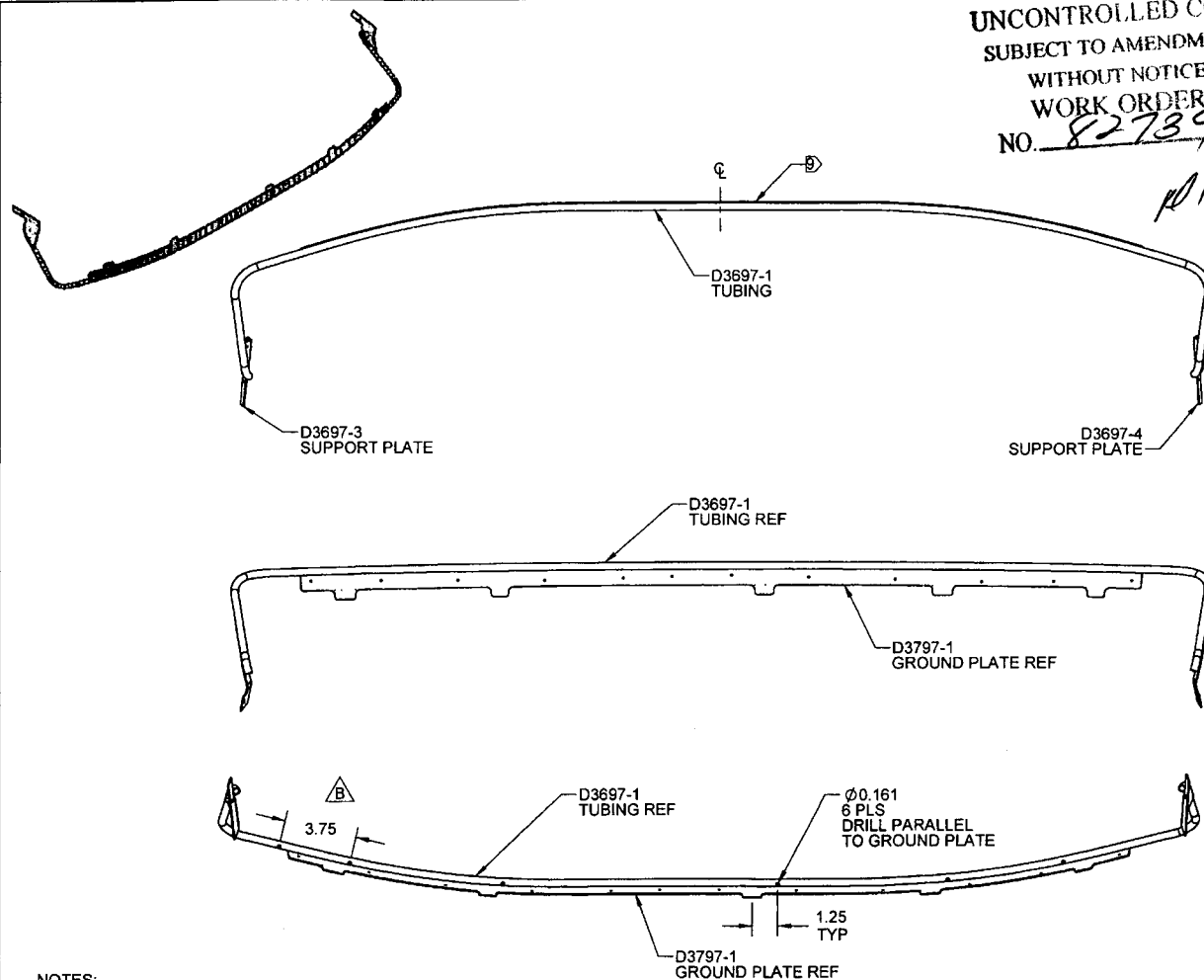
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SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82739

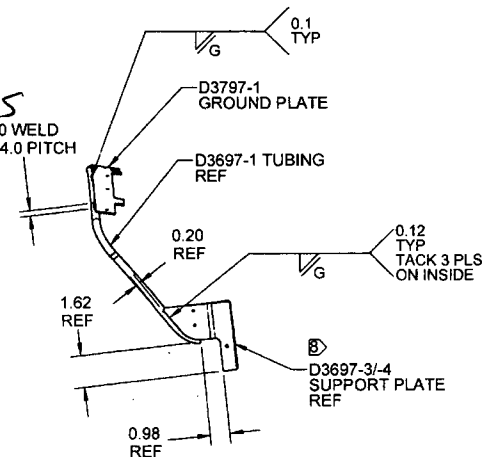
12 04-5
1.0 WELD
ON 4.0 PITCH



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY



RELEASED
05-07-06

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS SHEET 1 ZONE A.8; ADD Ø0.161 HOLE. SHEET 1 ZONE B.7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3697	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLY	NTS
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

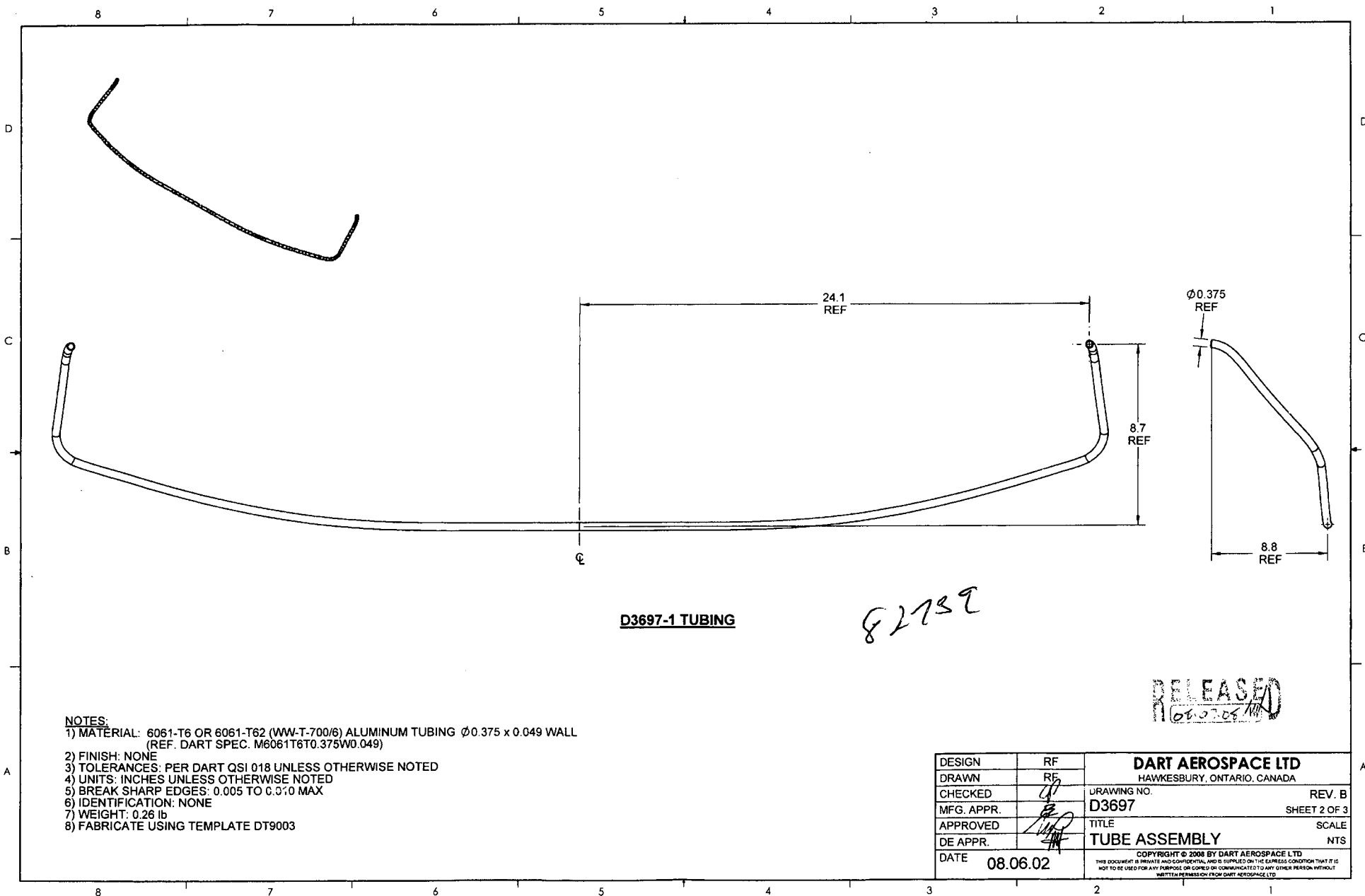
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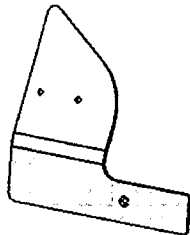
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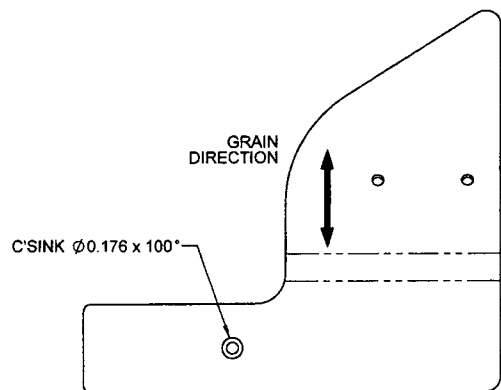
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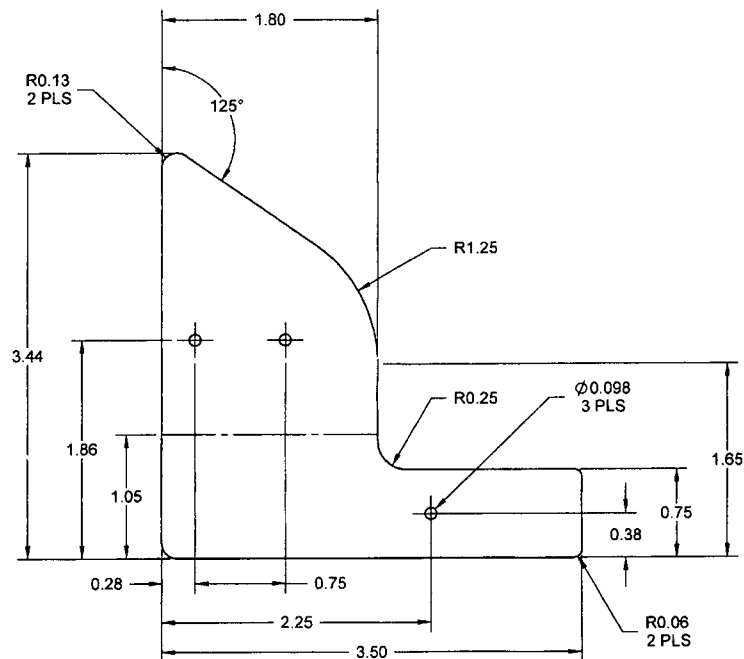
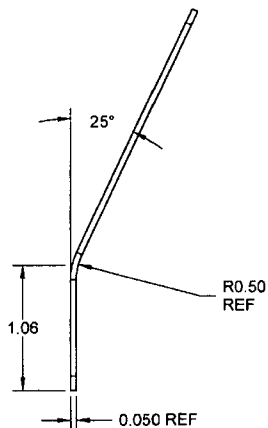
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

42739

RELEASED
 08-07-02

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3697	REV. B SHEET 3 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE TUBE ASSEMBLY	SCALE NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.	<i>[Signature]</i>		
DATE	08.06.02		

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